

**What is claimed is:**

1. Process for the formation of wood fiber board wherein a wood fiber stock suspension is dewatered on two sides between wires or felts forming a wood fiberboard having a basic weight of at least 1200 g/m<sup>2</sup>.
- 5 2. Process according to Claim 1 wherein dilution water is added locally to regulate the board thickness across the web running direction.
3. Process according to Claim 1 wherein headbox lips are set locally to regulate the board thickness across the web running direction.
4. Process according to Claim 1 wherein pre-dewatering takes place  
10 in a wedge zone.
5. Process according to Claim 1 wherein the stock is distributed over the working width by means of a cross-flow distributor and part of the wood fiber stock suspension flow is recirculated to the headbox.
6. Process according to Claim 1 wherein the wood fiber stock  
15 suspension is dewatered to a dry content of more than 40%.
7. Process according to Claim 1 wherein a top layer is applied after pre-dewatering.
8. Process according to Claim 7 wherein vacuum extraction is provided in the area where the top layer is applied.
- 20 9. Process according to Claim 7 wherein the wood fiber stock is further dewatered in a wedge zone after the top layer has been applied.

10. Process according to Claim 1 wherein several points are provided with line pressure.

11. Process according to Claim 10 wherein two to six points are provided with line pressure.

5 12. Process according to Claim 10 wherein three to five points are provided with line pressure.

13. Process according to Claim 1, wherein the wood fiber stock suspension is dewatered to a dry content of more than 45%.

10 14. Device for forming wood fiber board having a basic weight of 1200 to 8000 g/m<sup>2</sup> from a wood fiber stock suspension, the device comprising a first headbox and a main dewatering zone having a first top wire or felt and a bottom wire or felt.

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15. Device according to Claim 14 wherein the first top wire and the bottom wire form a first wedge zone.

15 16. Device according to Claim 15 wherein the first wedge zone is adjustable.

17. Device according to Claim 14 wherein the bottom wire runs essentially horizontally.

20 18. Device according to Claim 15 further comprising support means for supporting the wire or felt in the first wedge zone said support means comprising perforated plastic, steel plates, foil strips or table rolls.

19. Device according to Claim 14 further comprising a second headbox for applying a top layer.

20. Device according to Claim 19 further comprising a second dewatering zone having a second top wire or felt and the bottom wire  
5 or felt forming a second wedge zone.

21. Device according to Claim 20 wherein the wedge zones are suitable for pressure loading at an end.

22. Device according to Claim 14 further comprising several press nips, each of the press nips including opposed press rolls.

10 23. Device according to Claim 22 wherein the press rolls are arranged substantially vertically above one another.

24. Device according to Claim 22 wherein the press rolls in the press nips are suitable for individual pressure loading.

15 25. Device according to Claim 14 wherein the machine frame is suitable for cantilevering.

26. Device according to Claim 14 further including two to six press nips.

27. Device according to Claim 14 further including three to five press nips.

Year	1975	1976	1977	1978	1979	1980	1981	1982	1983	1984	1985	1986	1987	1988	1989	1990	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	2019	2020	2021	2022	2023	2024	2025	2026	2027	2028	2029	2030	2031	2032	2033	2034	2035	2036	2037	2038	2039	2040	2041	2042	2043	2044	2045	2046	2047	2048	2049	2050	2051	2052	2053	2054	2055	2056	2057	2058	2059	2060	2061	2062	2063	2064	2065	2066	2067	2068	2069	2070	2071	2072	2073	2074	2075	2076	2077	2078	2079	2080	2081	2082	2083	2084	2085	2086	2087	2088	2089	2090	2091	2092	2093	2094	2095	2096	2097	2098	2099	2100
1975	1976	1977	1978	1979	1980	1981	1982	1983	1984	1985	1986	1987	1988	1989	1990	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	2019	2020	2021	2022	2023	2024	2025	2026	2027	2028	2029	2030	2031	2032	2033	2034	2035	2036	2037	2038	2039	2040	2041	2042	2043	2044	2045	2046	2047	2048	2049	2050	2051	2052	2053	2054	2055	2056	2057	2058	2059	2060	2061	2062	2063	2064	2065	2066	2067	2068	2069	2070	2071	2072	2073	2074	2075	2076	2077	2078	2079	2080	2081	2082	2083	2084	2085	2086	2087	2088	2089	2090	2091	2092	2093	2094	2095	2096	2097	2098	2099	2100	